

Date: Friday, 9/7/2007 10:14:42 AM
User: Kim Johnston

Process Sheet

W37206-276

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34462
Estimate Number : 12364

Drawing Name : TAIL LIGHT FAIRING

P.O. Number :
This Issue : 9/7/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : LARGE FAB ASSY
Previous Run : 30764

Part Number : D3484041
Drawing Number : D3484 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 9/30/2007

Qty: 10 Um: Each

Written By :
Checked & Approved By :
Comment : Est Rev: A New Issue 06-04-11 JLM

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description:

1.0 D34841 BASE, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

BASE, LH

Batch: ~~XXXXXXXXXX~~ B 34456-1 → 7x

2.0 D34843 FACE, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

FACE, LH

Batch: B 34458 → 7

3.0 D34845 CONE, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

CONE, LH

Batch: ~~XXXXXXXXXX~~ B 34460-1 → 7x

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig

A/R AL ROD Batch: ~~XXXXXXXXXX~~ M104855

2-Buff & Smooth Welds to mating surfaces

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34462

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-22 (7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-24 (7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4.1

08-01-24

(17)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-24 (7)

9.0

MS20426AD33

CR 1122-5-02.5

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: M106878

(16) FF 08-01-25

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

ANCHOR NUT

Batch: M103693

(16) FF 08-01-25

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

(16) FF 08-01-25

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(16) 08/01/25 (16)

Q
2-50-2 5011 11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 34462

Part Number: D3484041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106379

BL 08-01-28

(7)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 0806/28

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 267

Identify on inside surface as indicated

TCCA-PDA,DART AEROSPACE LTD

P/N:D412-750-141 B/N:BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

8/1/28 SQ

(6x)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

120810/29

(6)

Job Completion



2 08-01-29

→ 15 B

Inspect level 5
Check P/N to Drawing

5 0806/28

Permanent Change
125

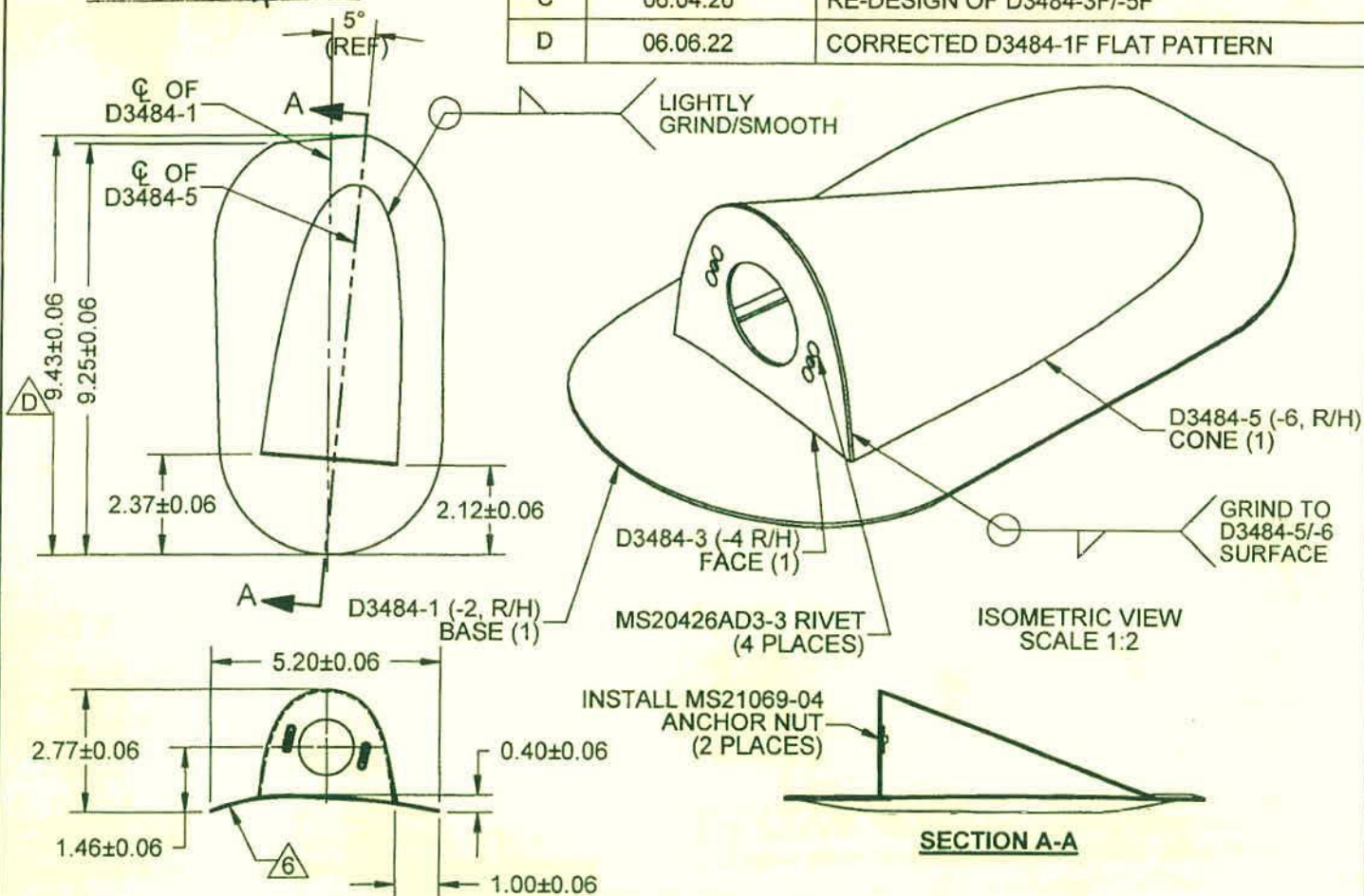
PTC

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3484	REV. D SHEET 1 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING	SCALE 1:4	
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17 H

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD.,
P/N D412-750-141/-142 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

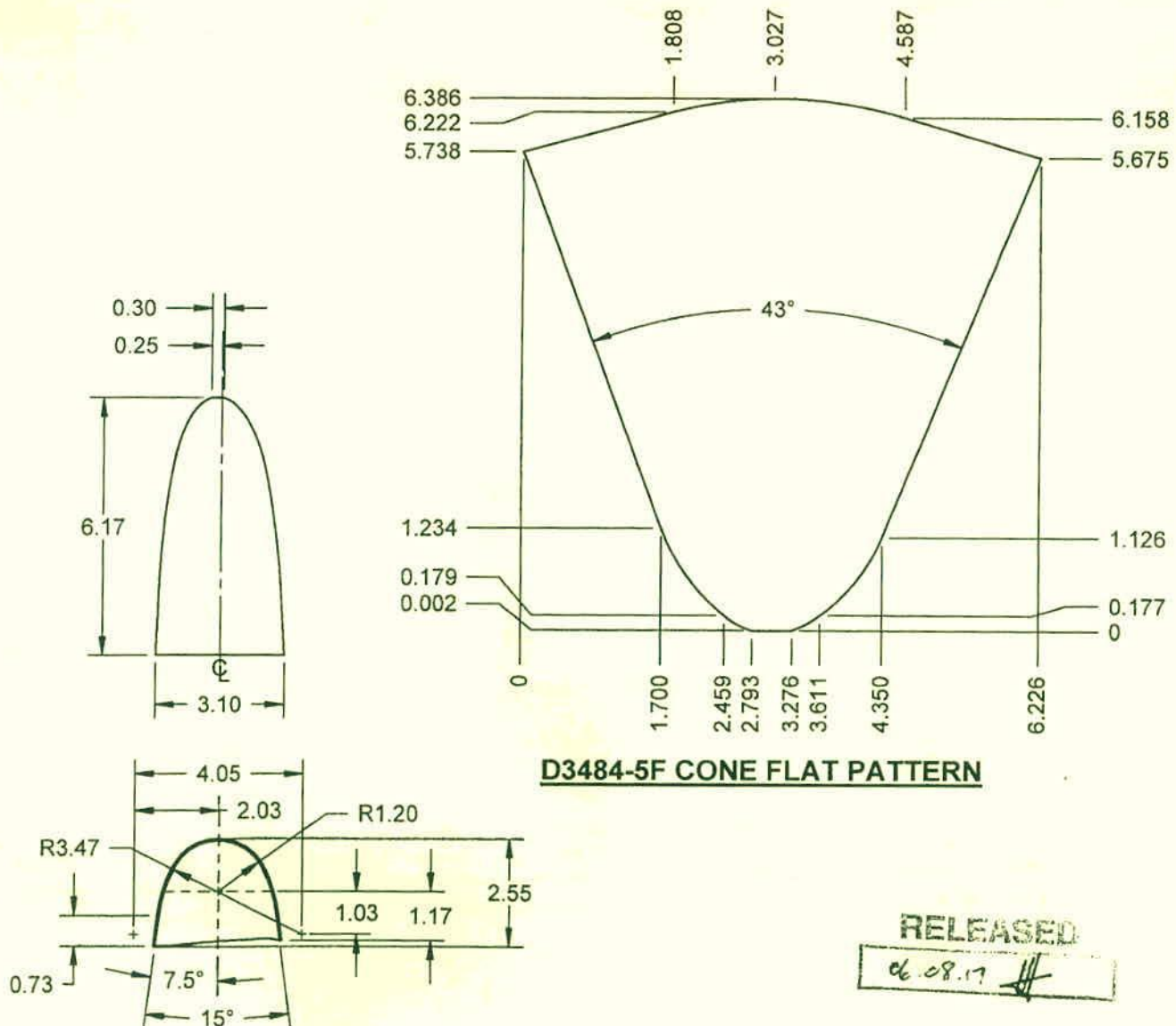
SHOP COPY
RETURN TO
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INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34462

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3484	REV. D SHEET 4 OF 4
DATE 06.06.22	TITLE TAIL LIGHT FAIRING		SCALE 1:4

**D3484-5F CONE FLAT PATTERN****RELEASED**06.08.17 *[Signature]***D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)**
(MAKE FROM D3484-5F)**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

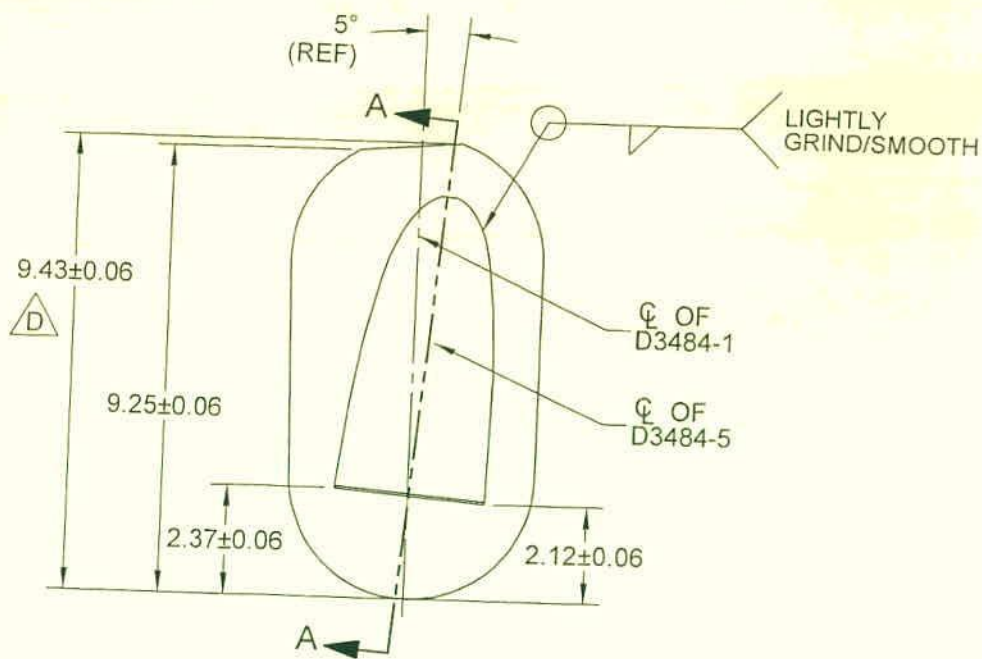
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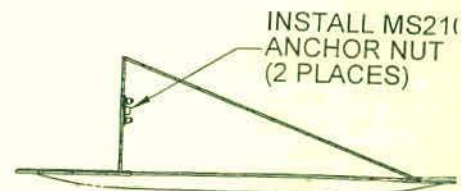
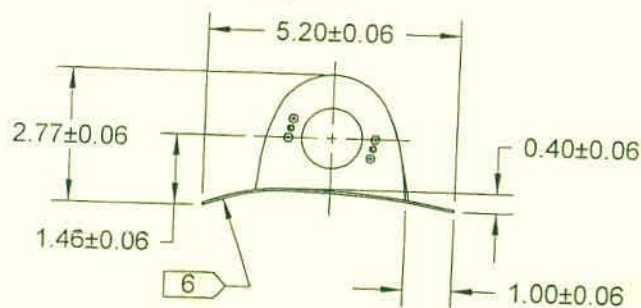
NO. *34462*

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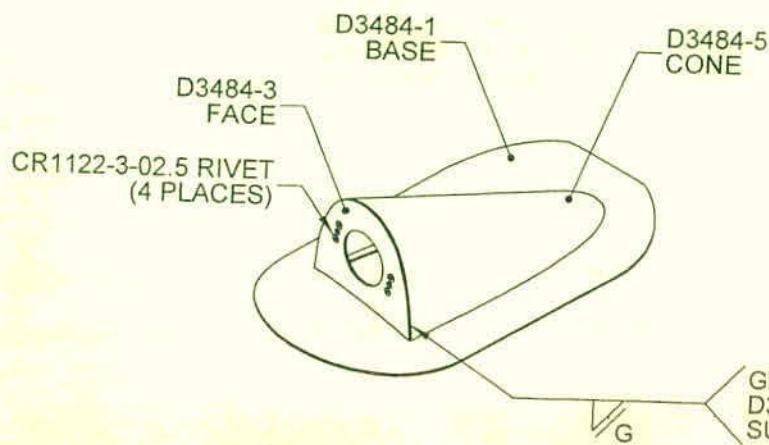


QTY -041	QTY -042
X	X
1	1
1	1
1	1
4	4
2	2



SECTION A-A

D3484-041 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WIT "TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXX
- 7) WEIGHT: 0.30 lbs

